

634-015

Dart Aerospace Ltd.

Date: Thursday, 23/10/2008 1:24:25 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SKID TUBE ASSEMBLY
Job Number	: 42897A		
Estimate Number	: 12520		
P.O. Number	:	Part Number	: D205634045
This Issue	: 23/10/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2580 REV D
First Issue	: 11	Project Number	: N/A
Previous Run	: 42896A	Drawing Revision	: D
	Type : SKIDTUBES	Material	:
Written By	:	Due Date	: 01/02/2009
Checked & Approved By	: <u>JLD 08-10-23</u>	Qty:	21 Um: Each
Comment	: Est Rev:C Revised Steps 06-09-06 JLM Est Rev:D Added SS Wearplates & Gaskets 07-07-09 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634-045 CHG002

N/A

2.0	D25001190	Ext'n -1' Beam Tube 4"
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	B375-414

JB 8-11-12

3.0	D2596	Web, 205 Skidtube
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	B-43074

AWM

8-11-13

(1x)

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
-----	-------------	-----------------------

**Comment:** LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends

3-Drill pilot holes using drill jig DT 8149

4-Acid etch and Alodine tube per QSI 005 4.1

7 JB 8-11-13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 42897A

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid

6-Countersink holes as per Dwg D2580 without cutting fluid

7-Deburr and blow out all chips from inside of tube

8-Add extra holes to web prior to bonding, per DEO 9183

9-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch
A/R Sikaflex-291 M109449
Sikaflex expire date: 08-11-30
Start Time: 330 Date: 8-11-13
Fin Time: 7:00 AM Date: 8-11-12

JB 8-11-13

AW 11
8-11-13

5.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

SL 8-11-24

6.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes.

2-Drill extra fwd hole as per DEO 9183 using
drill jig DT8461

3-Drill extra middle hole as per DEO 9183 using
drill jig DT8462

4-Drill pilot holes for aft cap using DT8215, ***DO NOT OPEN TO FINISH SIZE***

5-Drill extra aft holes as per DEO 9183 using
drill jig DT8463 locating from aft cap hole and aft saddle hole.

JB 8-11-17

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Part Number: D205634045

Job Number:



Seq. #: Machine Or Operation: Description :

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 08/11/17

8.0 D25763 Step (maching detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	238392

BE 08/11/17

9.0 D2579 Crossbolt Spacer



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
24	D2579	Spacers	41666

BE 08/11/17 (24)

10.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required.

JD 8-11-17

2-Weld step D2576 as per Dwg. D2580 and QSI 004.

A/R Aluminum Rod

M109813 BE 08/11/17

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004. For D2579

spacers, weld one

side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R Aluminum Rod

M109813 BE 08/11/17

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

5-Drill holes for wearplates using DT 8217 Open holes to 19/64", adjust stopper not to hit web. Debur

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

*****DO NOT COUNTERBORE EXTRA HOLES PUT IN AT STEP 13,14 AND 15 (LEAVE AT 0.384" Ø AS PER DEO 9183)****

JD 8-11-17




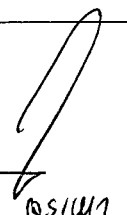


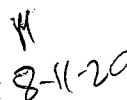
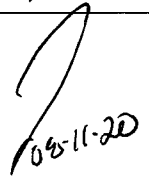


7-Open aft cap holes to #6 Drill bit. Debur

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D205-634-045 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: AA Date: 08.12.01

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>42897A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/11/20	#103	on 1st hole from Aft a pin hole was found during inspection. RC contamination during welding Tiny dust particle		Fill hole with weld as per Q67004				
				Grind weld flush. Buff pin hole lightly to remove				

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Job Number: 42897A

Part Number: D205634045

Job Number:



Seq. #: Machine Or Operation: Description :

11.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/11/26 (X)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/26 (X)

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M-h

08/11/26

(1X)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat ****GREEN****Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:45
320 OF
12:15

M-h

08/11/26

(1X)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-27

(X)

16.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch:

B335920

HL

17.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch:

M1100188

HL

08-11-27

(X)

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 42897A

Part Number: D205634045

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0	AN960JD10L	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M1105793

JP

19.0	AN960C10L	washer
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Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

washer

batch M1109798

JP

20.0	ALS71032130	Insert
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Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Insert

Batch: M1105819

* JP

21.0	AN3C4A	BOLT
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Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

BOLT

Batch: M1109798

JP

22.0	D356613	Gasket
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B342147

JP

23.0	D35665	Gasket
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B341467

JP

24.0	D35661	Gasket
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: B343264

JP

00-11-27

(K1)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 42897A

Part Number: D205634045

Job Number:



Seq. #:	Machine Or Operation:	Description :
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25.0	D356413	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B42257 *JH*

26.0	D356411	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B43192 *JH*

27.0	D35649	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B42258 *JH*

28.0	D35645	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE
Batch: B42236 *JH*

29.0	D25943	O-Ring, 205 Skidtube
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
O-Ring
Batch: B29908 *JH*

30.0	D25941	Plug, 205 Skidtube
------	--------	--------------------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Plug
Batch: B42807 *JH*

31.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291 M1109942 *JH*

08-11-27 *CU*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 42897A

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description :

Sikaflex expire date: 09/11

✓ 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

✓ 3-Inspect for foreign object per QSI 024

✓ 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

✓ A/R Sikaflex-291 1109942
Sikaflex expire date: 08/11

✓ 5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: 1109917

08-11-27 (R)

32.0

QC5

INSPECT WORK TO CURRENT STEP



S 08/11/27 @



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

33.0

PACKAGING 1

PACKAGING RESOURCE #1



5d

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-045

Location: _____

PPP Rev: _____

PPP 42897

Rev G

08/11/28 (R)

34.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/01 (R)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART

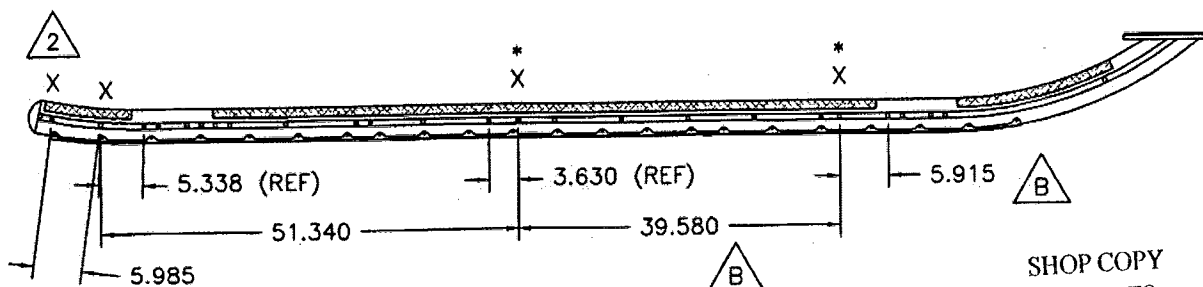
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. DEO 9183	REV. B SHEET 1 OF 1
DATE 00.05.15		TITLE ADD SKIDTUBE P/N D2580-045	SCALE NTS
A	00.03.29	NEW ISSUE	
B	00.05.15	39.580 WAS 39.620	

DART ENGINEERING ORDER

AMEND DRAWING D2580 REV. C TO ADD D2580-045 ASSEMBLY

D2580-045 IS IDENTICAL TO D2580-041, EXCEPT FOR THE FOLLOWING CHANGES:

- 1) INSTALL CROSS BOLT SPACERS AT LOCATIONS MARKED 'X' ACCORDING TO THE FOLLOWING PROCEDURE:
 - a) DRILL $\varnothing 0.508$ HOLES AT LOCATIONS SHOWN BELOW MARKED 'X'. CHAMFER HOLES $0.030 \times 45^\circ$. NOTE THAT HOLES WILL ALSO HAVE TO BE TRANSFERRED TO THE D2596 WEB AT THE * LOCATIONS. IT IS ACCEPTABLE TO PRE-DRILL THE D2596 WEB IN THESE LOCATIONS BEFORE INSTALLING THE WEB IN THE SKIDTUBE. OPEN HOLES TO $\varnothing 0.63$ AND TOUCH UP WITH ALODINE PER QSI 005 4.1.
 - b) INSERT D2579 CROSS BOLT SPACERS INTO THE HOLES.
 - c) WELD INTO PLACE PER DART QSI 004 AND GRIND FLUSH.
 - d) REMOVE SPILL OVER LEAVING HOLE DIMENSION $\varnothing 0.380$ - $\varnothing 0.390$.
- 2) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION.
- 3) POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 INSTEAD OF WHITE (REF. 4.3.5.1).



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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSI 9184	REV. A SHEET 1 OF 1
DATE 00.03.29		TITLE ADD SKIDTUBE P/N D205-634-015	SCALE NTS
A	00.03.29	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-634 REV. B.

REF. CANADIAN STA: SH96-88
US FAA STC: SR00563NY

ADD D205-634-015 INSTALLATION. PARTS LIST IS IDENTICAL
TO PARTS LIST FOR D205-634-011 EXCEPT THAT:
D205-634-045 REPLACES D205-634-041
D2580-045 REPLACES D2580-041

THE DIFFERENCE BETWEEN D205-634-011 (D205-634-041)
AND D205-634-015 (D205-634-045) IS THAT EXTRA
SPACERS HAVE BEEN ADDED AT LOCATIONS MARKED 'X' AND
ASSEMBLY IS PAINTED GREEN.



D205-634-015 (D205-634-045)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART**RELEASED**
07-06-28 #

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

NO. 173

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 91315 A0
Part number: D204 635041
Description: 204/205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat Duval Date of Test Coupon 080924
Welder Barclay Elliott Date of Test Coupon 080924

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Diagram illustrating the spacing of reinforcement bars in a circular cross-section. The diameter is 16 inches. The distance between the centerlines of the first and second bars is 3.500 inches. The distance from the centerline of the second bar to the right edge is 1.750 inches. The bars are shown with hooks at the top and bottom.

RELEASED
07-06-28-11

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{4}$

Technical drawing of a bolted joint assembly. The drawing shows a circular cross-section of a component with a central hole. A bolt is shown passing through the hole, secured with a washer and a cap. The following labels and dimensions are present:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to the two locations where the cap is installed.
- SEAL WITH SIKAFLEX-241/-291**: Points to the sealant applied to the joint.
- AN3-5A BOLT (1)**: Points to the bolt.
- AN96QJD10L WASHER (1)**: Points to the washer.
- (2 PLACES)**: Points to the two locations where the washer is installed.
- D2855 CAP**: Points to the cap.
- 0.208**: Dimension indicating the diameter of the hole.
- 0.40**: Dimension indicating the thickness of the component.

5

D2579 SPACER

D2596 WEB (REF)

ALST-1032-130 (REF)
(TYP 50 PLACES)

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

37.50
DISTANCE TO AFT END
OF D2596 WEB

3
7

1.750

1.750

Ø0.508 (TYP.)
(40 PLACES)

REFER TO DETAIL A

8.750

17.375

26.000

34.188

57.313 (REF)
7 EQUAL SPACES
8.188 PITCH

38.0

91.500

190.0
(D2500-1)

1.4

4

1.0

DISTANCE BETWEEN HOLE AND TANGENT POINT

13.4

20.0

4

0.640

1.0

DISTANCE BETWEEN HOLE AND TANGENT POINT

32.0 ± 1.0

11.0

D2000 0-1 ASSEMBLY DETAIL

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TO 0.5 ABOVE BOTTOM EDGE

0.5 1.5 1.5

8

P P P P P P P

REFER TO DETAIL C






D3566-1 D3566-5 D3566-1 D3566-13

D3564-11 D3564-5 D3564-9 D3564-13

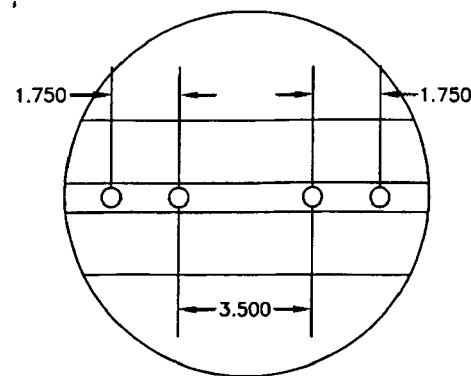
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

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WITHOUT NOTICE
13 WORK ORDER
NO. LC2897A

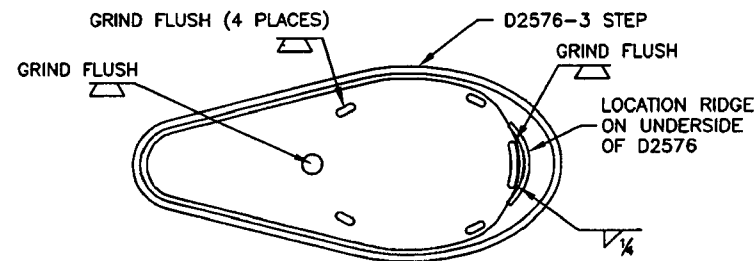
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	CHECKED 	APPROVED 	DRAWING NO. D2580	REV. SHEET 2 OF
	DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:2

DETAIL E
SCALE 5:24

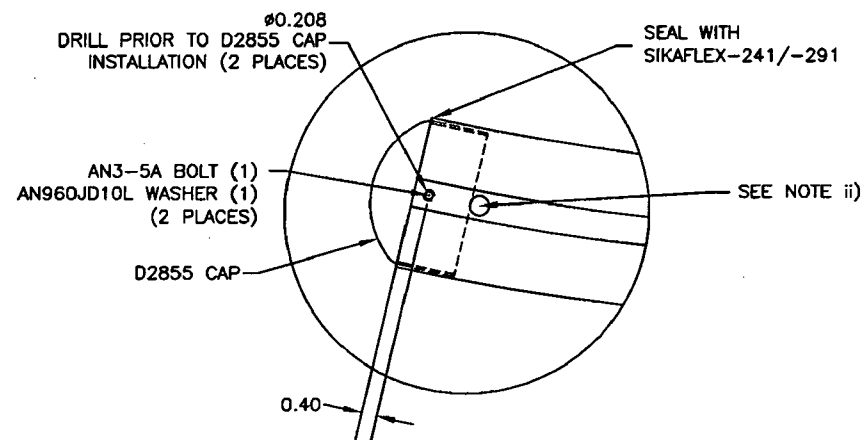


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07.02.28

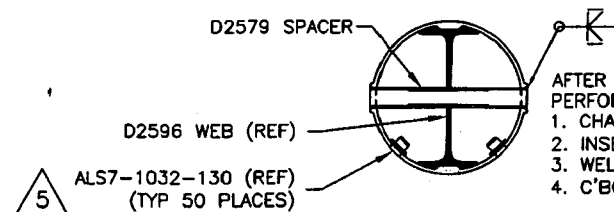
DETAIL F
SCALE 5:24



DETAIL G
SCALE 5:24

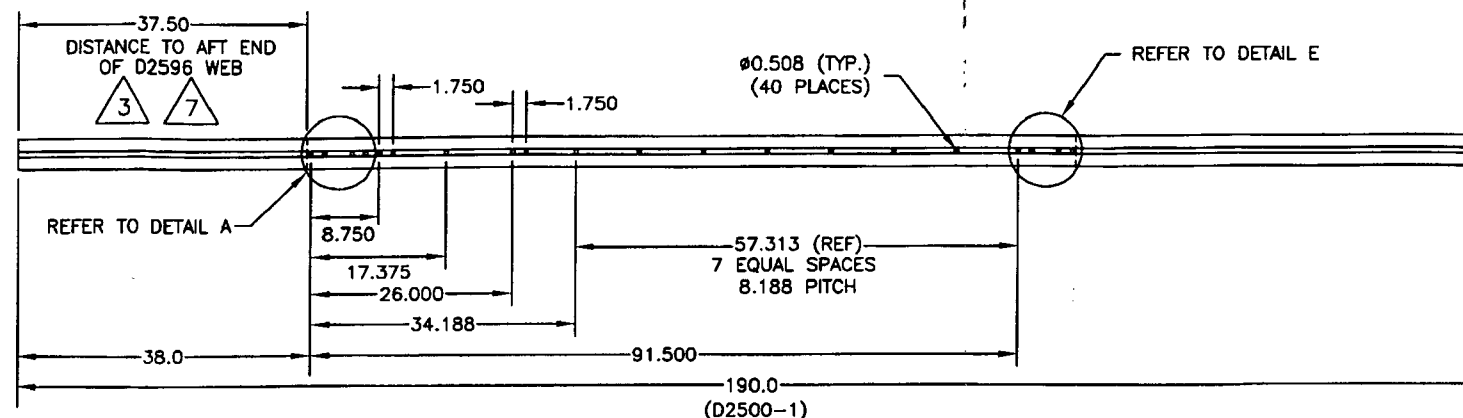


SECTION H-H
SCALE 5:24

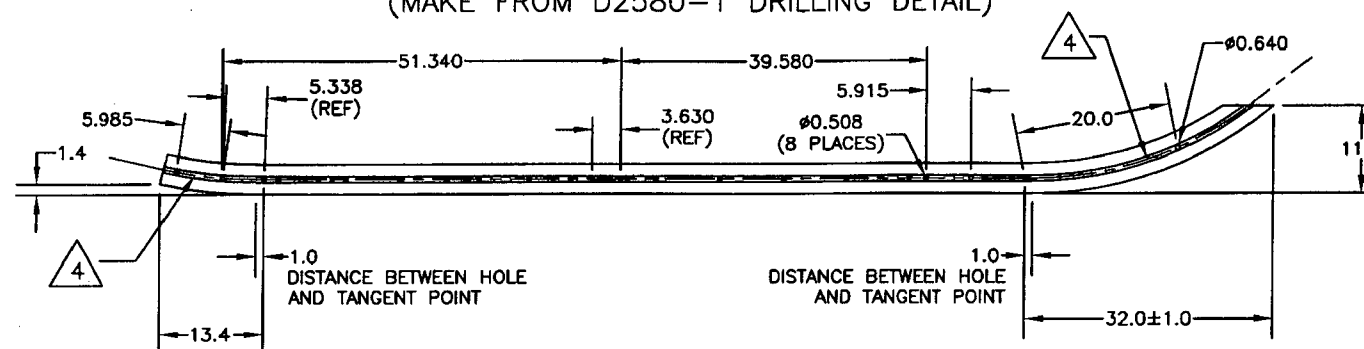


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
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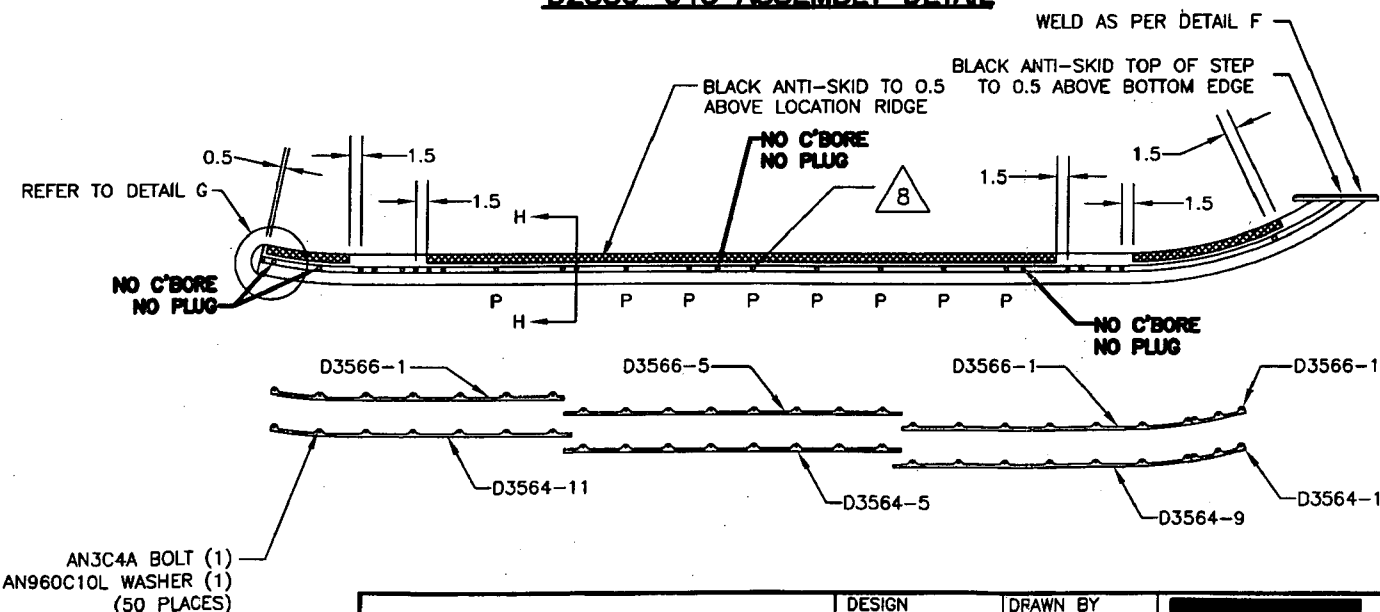
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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NO. 402897A

D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

